

Date: Thursday, 3/2/2006 3:05:37 PM
 User: Kim Johnston

Process Sheet

13

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR
 Job Number : 26016
 Estimate Number : 10877
 P.O. Number : N/A Part Number : D205711013
 This Issue : 3/2/2006 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : N/A
 Previous Run : 26015 Material : N/A
 Due Date : 3/30/2006 Qty: 1 Um: Each
 Written By : SEE COMMENT BELOW
 Checked & Approved By : 06-03-02-n
 Comment : Est Rev:A 04.11.09 New issue KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefiles and create labels per PPP D205-711-013 CHG001

EAGLE

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D412711041 Vertical Ref. Door Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D412-711-041 Vertical Reference DoorB25671
See Eagle

Attach serviceable tags

4.0 D205711113 Wiring Harness, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
1 D205-711-113 Wiring Harness, 205

EAGLE LOT # 2T-05-002169

Attach serviceable tags

345000-00 0851 30 06-000743

Date: Thursday, 3/2/2006 3:05:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR

Job Number: 26016

Part Number: D205711013

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

EA2046915205

Instrument Panel, 205



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

1 EA20469-15-205 Instrument Panel, 205 B19150

Attach serviceable tags

JP

6.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

4 hoodin

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-711-013

Location: GAUSE

PPP Rev: GAUSE

N/A

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06.07.17

Job Completion



U 06.07.14

Dart Aerospace Ltd.

Date: Monday, 1/30/2006 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25671
Estimate Number : 10902
P.O. Number : N/A
This Issue : 1/30/2006 S.O. No. : N/A
Prsht Rev. : NC
First Issue : N/A Type : PURCHASED PARTS
Previous Run : 25670
Written By : See COMMENT BELOW
Checked & Approved By : DL 06.01.30
Comment : Est Rev. 04.08.18 New Issue KJ/DS

Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY
Part Number : D412711041
Drawing Number : N/A
Project Number : N/A
Drawing Revision : N/A
Material : N/A
Due Date : 6/15/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description:

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 496 to Eagle Copters

Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041

Send a copy of this IPP

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door 42377

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 42377 06-0070841 EA20469-05 Rubber Strip 05-0028981 EA20469-06 Aluminum Strip W.O 403591 EA20469-07 Angle W.O 403591 EA20469-08 Placard W.O 403591 EA20469-10 Rear Rib Assy W.O 403591 EA20469-11 Angle W.O 40359

Date: Monday, 1/30/2006 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25671

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

1	EA20469-12	Fwd Rib	<u>W.D. 40357</u>
1	EA20469-13	Window	<u>W.D. 40357</u>
1	EA20469-14	Window Retainer	<u>W.D. 40357</u>
1	EA20469-16	Armrest Assy	<u>W.D. 40357</u>
1	EA20469-17	Angle	<u>W.D. 40357</u>
1	EA20469-18	Door Inner Skin	<u>W.D. 40357</u>
1	EA20469-21	Door Cover Panel	<u>W.D. 40357</u>
2	EA20469-23	Link	<u>W.D. 40357</u>
1	EA20469-24	Rod	<u>W.D. 40357</u>
1	EA20469-25	Arm Assy	<u>W.D. 40357</u>

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty Part Number Description Batch

14	AN3-3ABolt	AT05013698
22	AN3-4ABolt	AT05014656
24	AN3-7ABolt	AT05022609
6	AN960-6L Washer	LT01 3051
90	AN960-10L Washer	LT05 02200
34	CR3242-4-2 Rivet	AT05017444
135	MS20426AD3-3 Rivet	AT05 02240
140	MS20426AD4-3 Rivet	5382
25	MS20470AD3-3 Rivet	AT0502240
90	MS20470AD4-3 Rivet	AT0502240
24	MS21042L3 Nut	AT0502244
2	MS21042L06 Nut	AT0502244
13	MS21069L3 Nut Plate	AT0502238
8	MS21069L08 Nut Plate	AT0502230
1	MS21071L3 Nut Plate	AT0502243
1	MS21071L08 Nut Plate	AT0502247
9	MS21075L3 Nut Plate	AT0502240
2	MS24677-12 Screw	AT0501171
6	MS27039-1-09 Screw	AT0501676

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Date: Monday, 1/30/2006 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25671

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description:

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS

*Good*

Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

N/A STOCKED AT PAGE

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

D 06/05/08

Job Completion

*U 06-05-18*

Date: Monday, 1/30/2006 3:43:56 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY
 Job Number : 25671
 Estimate Number : 10902
 P.O. Number : Part Number : D412711041
 This Issue : 1/30/2006 S.O. No. : Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : / / Type : PURCHASED PARTS Drawing Revision : N/A
 Previous Run : 25670 Material : N/A
 Due Date : 6/15/2006 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *JD 06.01.30*
 Comment : Est Rev. 04.08.18 New Issue KJ/DS

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *496* to Eagle Copters *n Dec 2nd*

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door _____

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window _____

1 EA20469-05 Rubber Strip _____

1 EA20469-06 Aluminum Strip _____

1 EA20469-07 Angle _____

1 EA20469-08 Placard _____

1 EA20469-10 Rear Rib Assy _____

1 EA20469-11 Angle _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFFERENCE DOOR ASSEMBLY

Job Number: 25671

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	EA20469-12	Fwd Rib
1	EA20469-13	Window
1	EA20469-14	Window Retainer
1	EA20469-16	Armrest Assy
1	EA20469-17	Angle
1	EA20469-18	Door Inner Skin
1	EA20469-21	Door Cover Panel
2	EA20469-23	Link
1	EA20469-24	Rod
1	EA20469-25	Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty	Part Number	Description	Batch
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14	AN3-3ABolt		
22	AN3-4ABolt		
24	AN3-7ABolt		
6	AN960-6L	Washer	
90	AN960-10L	Washer	
34	CR3242-4-2	Rivet	
135	MS20426AD3-3	Rivet	
140	MS20426AD4-3	Rivet	
25	MS20470AD3-3	Rivet	
90	MS20470AD4-3	Rivet	
24	MS21042L3	Nut	
2	MS21042L06	Nut	
13	MS21069L3	Nut Plate	
8	MS21069L08	Nut Plate	
1	MS21071L3	Nut Plate	
1	MS21071L08	Nut Plate	
9	MS21075L3	Nut Plate	
2	MS24677-12	Screw	
6	MS27039-1-09	Screw	

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2006 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25671

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/30/2008 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 25671
Estimate Number : 10902
P.O. Number :
This Issue : 1/30/2006 S.O. No. :
Prsht Rev. : NC
First Issue : 11 Type : PURCHASED PARTS
Previous Run : 25670
Written By :
Checked & Approved By : 06.01.30
Comment : Est Rev. 04.08.18 New Issue KJ/DS

Drawing Name : VERTICAL REFERENCE DOOR ASSEMBLY
Part Number : D412711041
Drawing Number : N/A
Project Number : N/A
Drawing Revision : N/A
Material : N/A
Due Date : 6/15/2006 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: 496 to Eagle Copters

"Assembly of D412-711-041 Door Assembly in accordance with Dart IPP D412-711-041"

Send a copy of this IPP

2.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

EAGLE

Pick:Qty Part Number Description Batch

1 204-030-853-119 LH Co-pilot Door 42377

Attach serviceable tags

2- EAGLE

Fabricate/Pick the following parts to go into the door in accordance with:

D2046902 Sheet

1 Rev. 3

D2046902 Sheet 2 Rev. 2

D2046902 Sheet 3 Rev. 0

D2046901 Sheet 3 Rev. 1

Qty Part Number Description Batch

1 EB212-100L / EA20469-3 Window 42377 06-0070841 EA20469-05 Rubber Strip 05-0028981 EA20469-06 Aluminum Strip W.O 403591 EA20469-07 Angle W.O 403591 EA20469-08 Placard W.O 403591 EA20469-10 Rear Rib Assy W.O 403591 EA20469-11 Angle W.O 40359

Date: Monday, 1/30/2006 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25671

Part Number: D412711041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1	EA20469-12	Fwd Rib
1	EA20469-13	Window
1	EA20469-14	Window Retainer
1	EA20469-16	Armrest Assy
1	EA20469-17	Angle
1	EA20469-18	Door Inner Skin
1	EA20469-21	Door Cover Panel
2	EA20469-23	Link
1	EA20469-24	Rod
1	EA20469-25	Arm Assy

Material Certification / Proof of Traceability / Certificate of Conformity required

3-EAGLE

Pick:

Qty Part Number Description Batch

14	AN3-3ABolt	LT05015698
22	AN3-4ABolt	LT05024656
24	AN3-7ABolt	LT05022679
6	AN960-6L Washer	LT013007
90	AN960-10L Washer	LT05022682
34	CR3242-4-2 Rivet	LT05017444
135	MS20426AD3-3 Rivet	LT05002460
140	MS20426AD4-3 Rivet	53852
25	MS20470AD3-3 Rivet	LT05002440
90	MS20470AD4-3 Rivet	LT05002440
24	MS21042L3 Nut	LT05022644
2	MS21042L06 Nut	LT05022604
13	MS21069L3 Nut Plate	LT05022638
8	MS21069L08 Nut Plate	LT05022630
1	MS21071L3 Nut Plate	LT05022663
1	MS21071L08 Nut Plate	LT05022679
9	MS21075L3 Nut Plate	LT05023490
2	MS24677-12 Screw	LT05011731
6	MS27039-1-09 Screw	LT05016746

4-Assemble door in accordance with : D2046901 Sheet 2 Rev. 5 D2046901 Sheet 1 Rev. 5 Do not install EA20469-15 or wiring harness at this time.

5-Apply Dart P/N & B/N using fine point permanent marker

Date: Monday, 1/30/2006 3:43:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL REFERENCE DOOR ASSEMBLY

Job Number: 25671

Part Number: D412711041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

OC4

LEVEL 5 INSPECTION

INSPECT 100% KITS FOR COMPLETENESS



Handwritten signature



Comment: Eagle- INSPECT 100% KITS FOR COMPLETENESS

Send this W/O back to DartKit to be stocked at Eagle

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

5.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion

